

WHAT IS CLAIMED IS:

1. A color toner composition for developing latent electrostatic images comprising powder-coated toner particles, the powder-coated toner particles being characterized in that each comprises a core toner particle having a volume average diameter, D_p , and the core toner particles have affixed to their surfaces a plurality of discrete colorant powder particles having a volume average diameter, d_p , wherein the ratio of D_p/d_p is at least about 5 and the weight fraction of colorant powder particles is at least about 0.01 based on the combined weight of core toner particles and colorant powder particles.
2. The color toner composition according to Claim 1, wherein the ratio of the volume average diameter of the core toner particles to the volume average diameter of the colorant powder particles is at least about 10.
3. The color toner composition according to Claim 1, wherein the ratio of the volume average diameter of the core toner particles to the volume average diameter of the colorant powder particles is at least about 50.
4. The color toner composition according to Claim 1, wherein the ratio of the volume average diameter of the core toner particles to the volume average diameter of the colorant powder particles is at least about 100.
5. The color toner composition according to Claim 1, wherein the weight fraction of colorant powder particles is at least about 0.025 based on the combined weight of core toner particles and colorant particles.
6. The color toner composition according to Claim 5, wherein the weight fraction of colorant powder particles is at least about 0.05 based on the combined

weight of core toner particles and colorant particles.

7. The color toner composition according to Claim 1, wherein the weight fraction of colorant powder particles is from about 0.3 to about 3 times the product,
5 $(\rho_p/\rho_r) (d/r) (1+d/r)^2$, where ρ_p is the density of the colorant powder particles, ρ_r the density of the core resin particles, d , the volumetric mean diameter of the colorant powder particles and r the volumetric mean radius of the toner core resin particles.
- 10 8. The toner composition according to Claim 1, wherein 80 vol.% of the core toner particles are in the diameter range of about 0.5 to 1.5 times of the volumetric average diameter.
9. The toner composition according to Claim 1, wherein the resin core particles
15 further comprise a wax.
10. The toner composition according to Claim 9, wherein the resin core comprises a polymer selected from the group consisting of polyester resins and styrenic copolymer resins.
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11. The toner composition according to Claim 9, wherein the wax is selected from a group consisting of paraffinic wax, ester wax, amide wax, polyethylene wax, polypropylene wax, Canauba wax and bee's wax.
- 25 12. The toner composition according to Claim 9, wherein the resin core comprises a wax in the amount of from about 0 to about 30 weight percent parts of the toner composition.

13. The toner composition according to Claim 1, further comprising a charge control agent selected from a group consisting of negative and positive charge control agents.
- 5 14. The toner composition according to Claim 1, wherein the colorant powder particles comprise a pigment selected from the group consisting of cyan, magenta, yellow and black pigments.
- 10 15. The toner composition according to Claim 1, wherein the toner composition further comprises one or more particle flow agents selected from the group consisting of hydrophobic silica, hydrophilic silica, titanium oxide, zinc stearate, magnesium stearate, alumina, calcium titanate, polymethylmethacrylate particles, polyester particles and silicon polymer particles, as an external additive.
- 15 16. A particulate toner composition for development of latent electrostatic images comprising: toner particles consisting of a resin core consisting of a resin with the weight average molecular weight in the range of about 5,000 and about 40,000 g/mol and the glass transition temperature in the range of about 40°C and about 90°C; a colorant particle in the amount of about 3 to about 30 weight% embedded in the peripheral region of the core to form powder coated toner particles; and, optionally, a protective resin layer overcoated over the powder coated toner particles, wherein a volume average diameter of the toner particles is in the range of 3 and 12 microns with 80 vol.% of the particles in the diameter range of from about 0.5 to 1.5 times that of the volumetric average diameter.
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17. A color toner composition for developing latent electrostatic images comprising powder-coated toner particles, the toner particles being characterized in that each comprises a core toner particle having a volume average diameter, D_p , the toner particles having affixed to their surfaces a plurality of discrete colorant powder particles having a volume average diameter, d_p , as well as a melt-fused protective polymer operative to secure the powder to the core toner particles, wherein the ratio of D_p/d_p is at least about 5 and the weight fraction of colorant powder particles is at least about 0.01 based on the combined weight of core toner particles, colorant particles and protective resin.
18. A method of producing a toner composition for developing latent electrostatic images comprising:
- (a) admixing toner core particles having a volume average diameter, D_p , with a powder colorant composition having a volume average particle diameter, d_p , the ratio D_p/d_p being at least about 5; and
- (b) dispersing the powder colorant composition over the surfaces of the toner core particles under conditions effective to affix the powder to the surfaces of the core particles such that the core particles have a plurality of discrete toner particles of lesser size affixed to their surfaces.
19. The method according to Claim 18, carried out under substantially dry conditions.

20. A method of producing a toner composition for developing latent electrostatic images comprising:

- 5 (a) admixing toner core particles having a volume average diameter, D_p , with a powder colorant composition having a volume average particle diameter, d_p , the ratio D_p/d_p being at least about 5, and with a powder resin component having a volume average particle diameter, d_p , the ratio of D_p/d_p also being at least about 5;
- 10 (b) dispersing the powder colorant composition and the powder resin component over the surfaces of the toner core particles under conditions effective to affix the powders to the surfaces of the core particles such that the core particles have a plurality of discrete powder particles of resin and colorant of lesser size than the core toner
- 15 particles affixed to their surfaces; and
- (c) melting the powder resin component to further secure the powder colorant composition to the resin core particles.